

# Work Order ID 124878

**\*124878\***

Page 1

Thursday, September 25, 2014 1:06:39 PM

Item ID: D206-642-541 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: U/R *OK 9/24/14* Stop **\*NS2\***  
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)  
 Tri-Bag Float Comp  
 Start Date: 9/25/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 9/25/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MCS Date: 14-09-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274-041	F								
100	Document Control	0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-642-541		CHG005						

*N/A* *OK*

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**Accept**

**\*N900040100\***

**Setup**   **Start**   **\*NS1\***

Revision ID: U/R

**Item Name:** Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)  
Tri-Bag Float Comp

Stop \*NS2\*

**Start Date:** 9/25/2014      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 9/25/2014      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:**                      **Date:**                      **Tooling:**                      **Date:**

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Sequence ID/  
Work Center ID**  
110

### Operation Description

**Set Up/  
Day Hours**  
0.00

[illegible]

**\*110\***

## Skidtubes

0.00

## Skidtubes

## Skidtubes

## Memo

\*\*\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*\*

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding

2- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch:

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

**6-Drill** Aft cap pilot hole using DT8025

6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DGL 14-9-20

BE14-09-29

14-9-30

D6C 14-9-30

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**Item ID:** D206-642-541

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID: U/R

**Item Name:** Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)  
Tri-Bag Float Comp

Stop \*NS2\*

**Start Date:** 9/25/2014      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 9/25/2014      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114	QC5- Inspect part completeness to step on W/O	0.00							

**\*1 14\***

QC

## Memo

0.00

## Quality Control

**DAS**  
**9**  
**9-89**

116

QC10- Inspect visual per QSI004- ground welds

0.00

**\*1 16\***

QC

## Memo

0.00

## Quality Control

**DAS**  
**B**  
**8-89**

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

**HandFinish**

## Memo

0.00

## Hand Finishing

Doc

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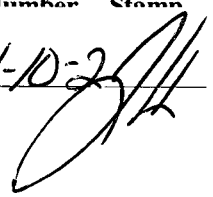

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Item ID: D206-642-541 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: U/R Stop **\*NS2\***  
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp  
Start Date: 9/25/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 9/25/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00				①	0	14-10-2	
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
150	Skidtubes	0.00				1	0	14-10-02	
<b>*150*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <b>127457</b>								
	Sikaflex expire date: <u>11-11-20</u>								
	Start: _____ Time: <u>10:20 AM</u>								
	Finish: _____ Time: _____								
	(Adhere for 12 hours)								

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**Item ID:** D206-642-541 **Accept** **\*N900040100\*** **Setup Start \*NS1\***  
**Revision ID:** U/R **Stop \*NS2\***  
**Item Name:** Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)  
**Start Date:** 9/25/2014 **Start Qty:** 1.00 **\*1\*** **Cust Item ID:**  
**Required Date:** 9/25/2014 **Req'd Qty:** 1.00 **\*1\*** **Customer:**  
**Reference:**

**Approvals:** **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run Start \*NR1\***  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop \*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170		0.00							
<b>*170*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.								
	2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr								
	3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES								
	4- Countersink crossbolt spacer holes as per Dwg D3274								
	5- prepare for welding								

DAS 03 9-29

14-10-3

DGL 14-10-06

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**Item ID:** D206-642-541

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID: U/R

**Item Name:** Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)  
Tri-Bag Float Comp

Stop \*NS2\*

**Start Date:** 9/25/2014      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 9/25/2014      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID  
180

<b>Operation</b>	<b>Description</b>
QC5-	Inspect part completeness to step on W/O

Set Up/ Data Points	Tool
0.00	47°

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

**DAS**  
**18**  
**9-89**

**\*1 20\***  
QC

# Memo

0.00

## Quality Control

190

0.00

**\*190\***

## Skidtubes

0.00

## Skidtubes

## Skidtubes

## Memo

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod  
A/RAluminum Rod *m125127* *BT14*

3-Grind cross bolt welds flush as per Dwg D3274.  
 \*\*\*\*INSPECT FOR PIN HOLES IN WELD\*\*\*\*

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

14-10-8

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**Revision ID:** U/R **Stop** **\*NS2\***  
**Item Name:** Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)  
**Start Date:** 9/25/2014 **Start Qty:** 1.00 **\*1\*** **Cust Item ID:**  
**Required Date:** 9/25/2014 **Req'd Qty:** 1.00 **\*1\*** **Customer:**  
**Reference:**

**Approvals:** **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run Start** **\*NR1\***  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop** **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamps
200	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
<b>*200*</b>									
QC	Memo	0.00				① 14-20			
Quality Control									
210	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*210*</b>									
QC	Memo	0.00				① 14-10-20			DAS 9 9-89
Quality Control									
220	Pressure Wash per QSI005 4.3	0.00							
<b>*220*</b>									
HandFinish	Memo	0.00				① 14-10-22			
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch								

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Item ID: D206-642-541 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: U/R Stop \*NS2\*  
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp  
Start Date: 9/25/2014 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 9/25/2014 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
*230*									
SprayPaint	Memo	0.00							
Spray Painting	Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>12895</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>129977</u>								CL 14.10.22
240	QC14- Inspect Spray Paint	0.00							
*240*									
QC	Memo	0.00							
Quality Control									
244	Wing Walk as per dwg QSI005 4.4 Batch <u>141302006</u>								
*244*									
HandFinish	Memo	0.00							
Hand Finishing									

DAS  
15  
9-89



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Item ID: D206-642-541 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: U/R Stop **\*NS2\***  
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp  
 Start Date: 9/25/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 9/25/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
246	QC3- Inspect Part Finish	0.00				1			DAS 38 9-89
<b>*246*</b>									
QC	Memo	0.00							
Quality Control									14-11-11
250	HandFinishing	0.00							
<b>*250*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 11122960

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291 1136229

Sikaflex expire date: 15106

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Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)  
Tri-Bag Float Comp  
Start Date: 9/25/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 9/25/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
<b>*260*</b>									
QC	<i>X</i> Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								14-11-7
270		0.00							
<b>*270*</b>	HAND FINISHING RESOURCE #1								
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads & gaskets as per Dwg D3274.								
	2-Install ring as per Dwg D3274								
	A/RSikaflex-291 <u>M1130227</u>								
	Sikaflex expire date: <u>15109</u>								
	3-Inspect for foreign objects as per QSI 024								
	4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.								
	A/RSikaflex-291 <u>M123227</u>								
	Sikaflex expire date: <u>15109</u>								

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Item ID: D206-642-541 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp  
Start Date: 9/25/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 9/25/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC5- Inspect part completeness to step on W/O	0.00							38 9-29 14-11-11
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									
290	Identify as per dwg & Stock Location: _____	0.00							
<b>*290*</b>									
Packaging	Memo	0.00							
Packaging									
300	QC21- Final Inspection - Work Order Release	0.00							
<b>*300*</b>									
QC	Memo	0.00							
Quality Control									

NOV 18 2014  
PP124 870

DAS  
05  
9-29

14/11/19

14.11.19

# Picklist Print

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Work Order ID: 124878

**\*124878\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

Start Qty: 1.00

Required Qty: 1.00

**Comments:**

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM  
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
 IPP Rev:F 08-06-02 add comment DD verified by:EC  
 IPP Rev:G 08-10-09 revise details DD verified by:EC IPP  
 REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I  
 14.04.28 AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3274-041BENT		Manufactured	No			110	Each	10.0000	1	1			

**\*D3274-041BENT\***

Skidtube Assembly 206

\*\*

Doc 14-9-26

Location	Loc Qty	Loc Code
LG002	10	
113682	1	
<del>120287</del>	9	

D4956-15 Manufactured No

270 Each 14.0000 1

1

**\*D4956-15\***

Stainless Steel Wearplate Fwd

\*\*

11/11/07

Location	Loc Qty	Loc Code
FP002	14	
120326	2	
122996	12	

D4956-23 Manufactured No

270 Each 10.0000 1

1

**\*D4956-23\***

Stainless Steel Wearplate Center Fwd

\*\*

11/11/07

Location	Loc Qty	Loc Code
FP002	10	
121755	10	

11

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Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART  
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D4956-35 Manufactured No 270 Each 12.0000

Start Qty: 1.00

Required Qty: 1.00

**\*D4956-35\***

Stainless Steel Wearplate Aft

\*\*

*all ululoz*

Location	Loc Qty	Loc Code
FP002	12	
120577	1	
121975	11	

D4956-39 Manufactured No 270 Each 9.0000

**\*D4956-39\***

Stainless Steel Wearplate Center Aft

\*\*

*all ululoz*

Location	Loc Qty	Loc Code
FP002	9	
121857	9	

D3285-1 Manufactured No 110 Each 5.0000

**\*D3285-1\***

Cap

\*\*

*BB14-0929*

Location	Loc Qty	Loc Code
LG001	5	
108052	5	

D3282-041 Manufactured No 150 Each 7.0000

**\*D3282-041\***

Float Web (206L/407)

\*\*

*DEL 14-1002*

Location	Loc Qty	Loc Code
LG002	7	
113149	1	
119524	6	

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Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART  
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D2649

Manufactured No

190

Each

Start Qty: 1.00  
415.0000 12 12

Required Qty: 1.00

**\*D2649\***

Cross Bolt Spacer

\*\*

BE14-10-07

Location

Loc Qty

Loc Code

LG

203

123099

203

12

LG001

212

107906

3

112728

6

113811

2

120508

195

90497

6

D3275-1

Manufactured No

190

Each

191.0000 12 12

**\*D3275-1\***

Crossbolt Spacer

\*\*

BE14-10-07

Location

Loc Qty

Loc Code

LG001

191

113246

1

113851

62

144877

65

121868

1

121974

62

10

CR3212-4-03

Purchased No

250

Each

998.0000 2 2

**\*CR3212-4-03\***

Cherry Rivet

\*\*

11/14/07

Location

Loc Qty

Loc Code

ST321

998

114889

1

119017

700

m114859

100

m123265

197

X2

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Shop Packet Print

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**\*124878\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART  
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3415-041 Manufactured No

250 Each

19.0000 Start Qty: 1.00 1 1

Required Qty: 1.00

**\*D3415-041\***

Nut Plate

\*\*

*ll ululobz*

Location

Loc Qty

Loc Code

ST037

19

113764

19

x1

CCR264SS3-3

Purchased No

250 Each

431.0000 2 2

**\*CCR264SS3-3\***

Cherry Rivet

\*\*

*ll ululobz*

Location

Loc Qty

Loc Code

ST321

431

113973

26

m126282

47

m126333

70

m128636

88

m128818

200

x2

ALS4-1032-130

AEALS4-1032-130 Purchased

No

250 Each

4,073.000 78 78

**\*ALS4-1032-130\***

Rivnut

\*\*

*ll ululobz*

Location

Loc Qty

Loc Code

ST267

4073

M126109

57

M128211

48

M128649

3968

y7%

# Picklist Print

Thursday, September 25, 2014 1:06:43 PM

Work Order ID: 124878

**\*124878\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART  
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3537-3 Manufactured No

270 Each 60.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

**\*D3537-3\***

Wearpad

\*\*

*ll 4/1/07*

Location	Loc Qty	Loc Code
FG	8	
86237	8	
FP001	12	
111825	1	
113789	1	
115122	10	
FP002	40	
120646	40	

*x1*

D3537-1 Manufactured No

270 Each 78.0000 9 9

**\*D3537-1\***

Wearpad

\*\*

*ll 4/1/07*

Location	Loc Qty	Loc Code
FG	18	
79833	8	B124485
88562	10	B125699
FP001	60	
113839	4	
120644	37	
120645	18	
93945	1	

*x4*

*x5*





# Picklist Print

Thursday, September 25, 2014 1:06:43 PM

Page 7

Work Order ID: 124878

**\*124878\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART  
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3672-1

Manufactured No

270

Each

955.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

**\*D3672-1\***

Washer, Phenolic

**\*\***

*lll 12/10/14*

Location

Loc Qty

Loc Code

FG

10

85222

10

ST055

945

103845

4

113581

474

120116

421

80369

34

99099

12

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
x 2  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

AN3C4A

Purchased

No

270

Each

1,103.000

80

80

**\*AN3C4A\***

Bolt

**\*\***

*lll 12/10/14*

Location

Loc Qty

Loc Code

FG

20

122814

20

ST350

1083

124221

12

M127410

1

M127832

62

M128606

32

M128634

8

M128739

4

M128879

71

M129520

893

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
x 80  
\_\_\_\_\_

# Picklist Print

Thursday, September 25, 2014 1:06:43 PM

Page 8

Work Order ID: 124878

**\*124878\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART  
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

AN4C5A

Purchased

No

270

Each

56.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

**\*AN4C5A\***

Bolt

\*\*

*lll uluboz*

Location

Loc Qty

Loc Code

ST355

56

122599

3

123265

1

M127410

10

M128403

42

x1

D2646

Manufactured

No

270

Each

57.0000

1

1

**\*D2646\***

Aft Cap

\*\*

*lll uluboz*

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

12

103306

2

107857

1

110816

1

113830

2

114495

6

FP002

41

119656

41

x1

# Picklist Print

Thursday, September 25, 2014 1:06:43 PM

Work Order ID: 124878

**\*124878\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART  
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3413-1

Manufactured No

270

Each

33.0000

Start Qty: 1.00

Required Qty: 1.00

1

1

**\*D3413-1\***

**\*\***

*all 146107*

O-Ring

Location

Loc Qty

Loc Code

ST525

33

106048

1

110715

11

112309

6

114489

3

114528

1

116664

1

120218

10

✓

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2800-1-240	EXTRUSION
1	1	D2846	AFT CAP
12	12	D2848	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4856-15	WEARSHOE
1	1	D4856-23	WEARSHOE
1	1	D4856-35	WEARSHOE
1	1	D4856-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN860C418	WASHER
80	80	AN860C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

#### GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB  
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: 20.8 LBS
8. WELDING TO BE DONE PER DART QSI 004.
9. ALL HOLES DRILLED ON CENTERLINES.
10. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
12. DRILL 20.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/-291.
13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.



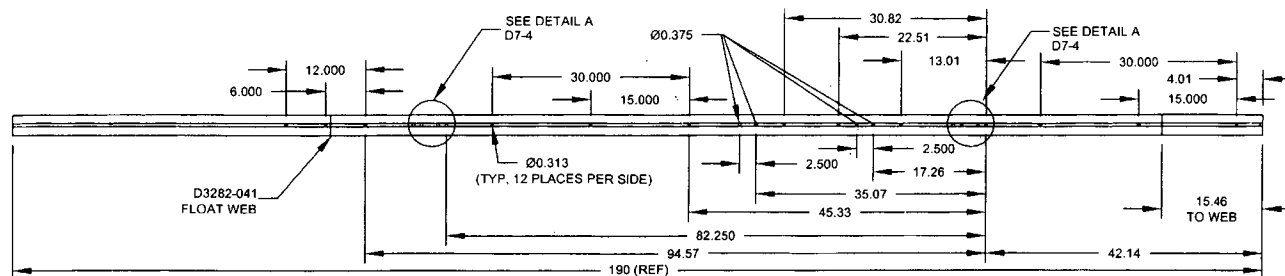
SHOP COPY  
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ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 124878 MLS

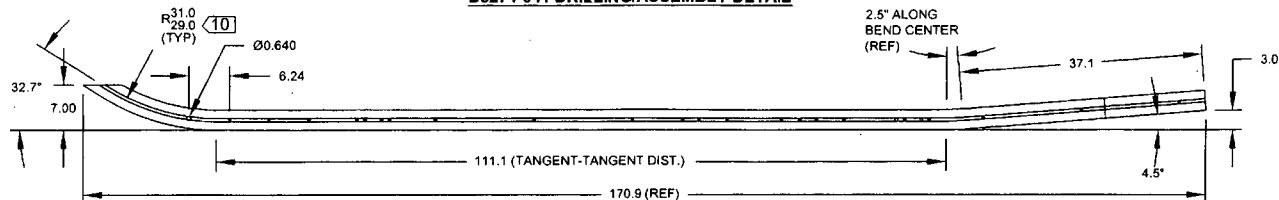
14-09-25

RELEASED  
2014-05-26  
MD

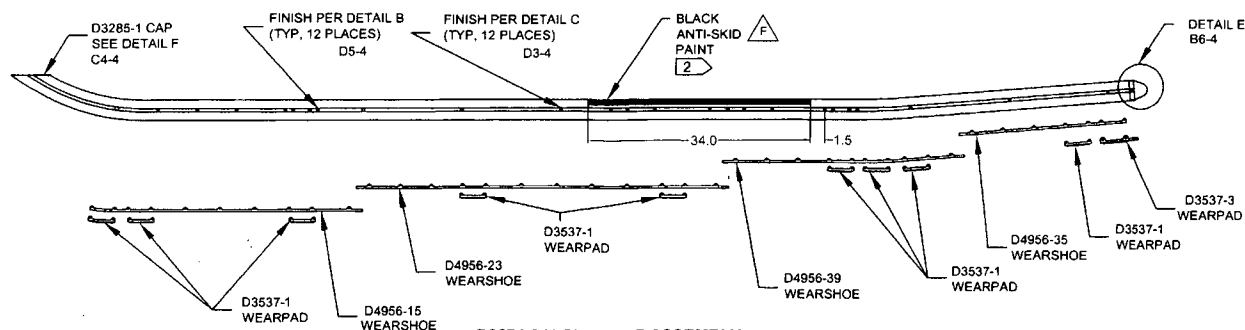
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-842 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT © 2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD	



**D3274-041 DRILLING/ASSEMBLY DETAIL**



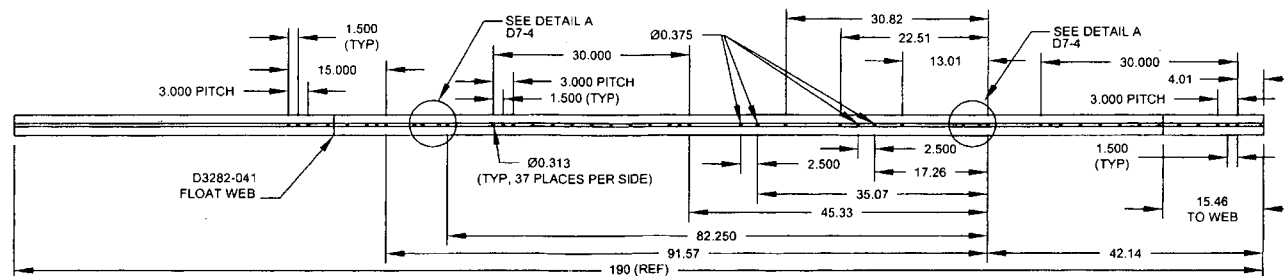
**D3274-041 BEND/DRILLING DETAIL**



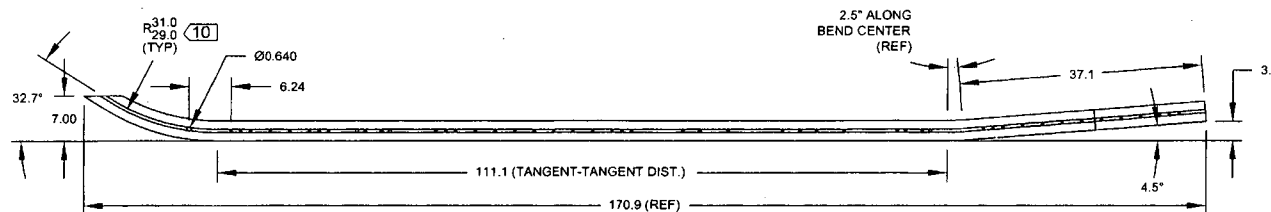
**D3274-041 SKIDTUBE ASSEMBLY  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

**RELEASED**  
2014-05-26

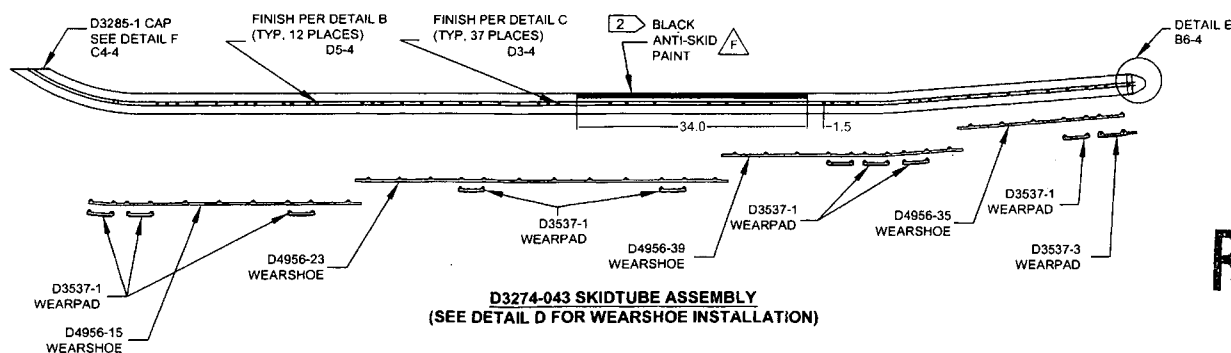
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DRAWN	DB		
CHECKED	<i>DB</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>DB</i>	D3274	SHEET 2 OF 4
APPROVED	<i>MT</i>	TITLE	SCALE
DE APPR.	<i>MT</i>	SKIDTUBE ASSEMBLY	NTS
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**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**

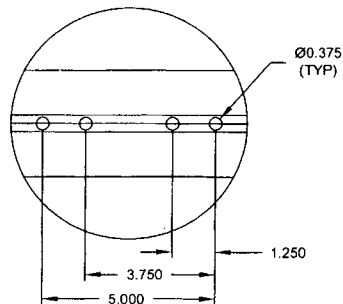


**D3274-043 SKIDTUBE ASSEMBLY  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

**RELEASED**  
2014-05-26

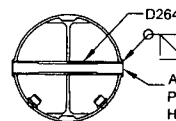
DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	DB	KENT, WA	
CHECKED	<i>DB</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	4.04.15
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	

**DETAIL A: DRILL DETAIL**  
D6-2, D3-2, D5-3, D3-3



**DETAIL B**  
B6-2, B5-3

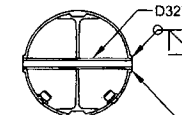
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375  
HOLES ONLY:  
1. CHAMFER HOLE 0.030x45°  
2. INSERT D2649 SPACER  
3. WELD INTO PLACE AND GRIND FLUSH  
4. CBORE TO Ø0.313x0.75 DEEP

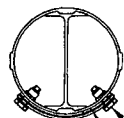
**DETAIL C**  
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°  
(TYP)

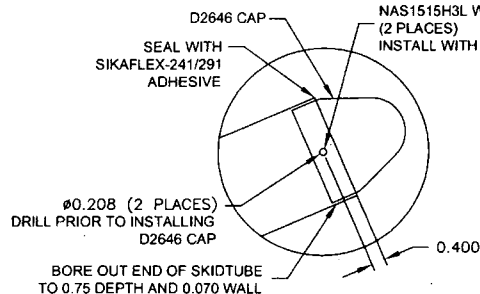
**DETAIL D**  
A4-2, A4-3



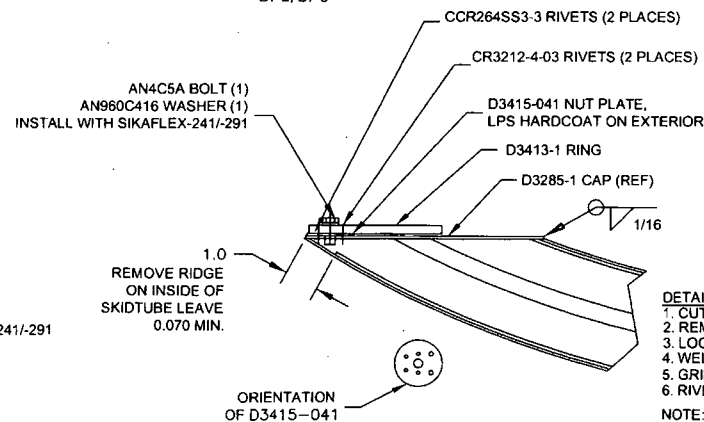
AL57-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

**DETAIL E**  
B2-2, B2-3



**DETAIL F: END FINISHING DETAIL**  
B7-2, B7-3



**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**RELEASE**  
2014-05-26

DESIGN	CP	<b>DART AEROSPACE LTD</b> KENT, WA	
DRAWN	DB		
CHECKED	JP	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 4 OF 4
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elle

---

Mike Petsche  
June-24-14 3:17 PM  
Linda Lacelle  
RE: D206-642-541 floats

I say just assemble them. The powder coat won't last long anyway

---

a Lacelle  
day, June 24, 2014 12:40 PM  
tsche; David Shepherd; Chris Provencal  
rbes  
E: D206-642-541 floats

ed with assembly? We have about 10 on the go right now. I really don't want to wait to have more made...we have 79 of the painted in stk of D3537-  
the D3537-3's. shall I get all the w/o's off the shop floor and remove the powder coat? Do I need someone to sign this off?

---

Petsche  
24-14 12:38 PM  
acelle; David Shepherd; Chris Provencal  
rbes  
E: D206-642-541 floats

eally. But ideally we should remove the powder coat from the dwg

---

a Lacelle  
lay, June 24, 2014 12:36 PM  
epherd; Mike Petsche; Chris Provencal  
rbes  
206-642-541 floats

anyone that can answer me:  
arplates D4956-XX that replace the D3535-XX are SS unpainted, but the wearpads D3537-1/-3 are painted, does this matter?